

split SHIP JAN 14th 11:00

Work Order ID 55184-2



Page 1

January 8, 2010 1:44:39 PM

Item ID: D3262-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Canister Assembly

3

Start Date: 1/08/10

Start Qty: 4.00



Cust Item ID:

Required Date: 1/12/10

Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3262

Rev C

100

Weld per dwg A/R Aluminum rod Batch: 0.00



Large Fab

Large Fab

Memo

0.00

M112860

Large Fab

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Cpl 10/01/18

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

(+3)

BE 10/01/19

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

Pressure test as per Dwg D3262

⇒ Sub 19

(+3)

Work Order ID 55184

January 8, 2010 1:44:40 PM



Page 2

Item ID: D3262-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Canister Assembly

Start Date: 1/08/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/12/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

ML 10/01/19

(X3) 0

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M113170

Memo

0.00

=> ML 10/01/19

(X3) 0

Powder Coating

****Ensure to mask threads ****

START TIME:

10:00AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:30AM

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BR 10-01-19

(3)

Quality Control

Work Order ID 55184

Page 3

January 8, 2010 1:44:41 PM

Item ID: D3262-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Canister Assembly

Start Date: 1/08/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/12/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: MM

0.00

Memo

0.00

Packaging

10-1-19

(3x) SP

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/01/20 *[Signature]*

ME 10-1-19

Picklist Print

January 8, 2010 1:44:38 PM

Page 1

Work Order ID: 55184



Parent Item: D3262-041



Parent Item Name: Canister Assembly

Start Date: 1/08/10

Required Date: 1/12/10

Comments: IPP C05.03.10 Removed P/O for liquid penetrant inspection KJ/JLM

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

| | | | | | | | | | | | | |
|---------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|
| D3262-1 | | Manufactured | No | | | 100 | Each | 6.0000 | 4.0000 | | | |
|---------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|



Tube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53504

6

6

| | | | | | | | | | | | | |
|---------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|
| D3262-3 | | Manufactured | No | | | 100 | Each | 0.0000 | 8.0000 | | | |
|---------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|



Cap

40/01/11
Pl 10/01/18

(4) ex

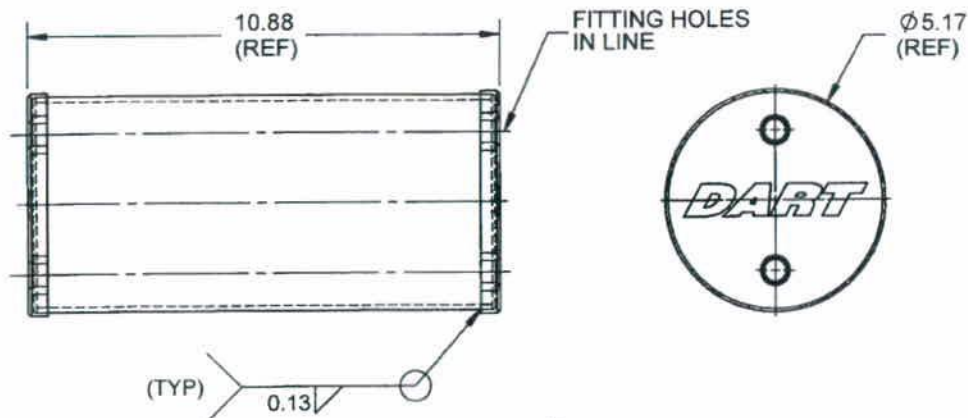
B53503

10-1-11 EQ

Pl 10/01/18

DART

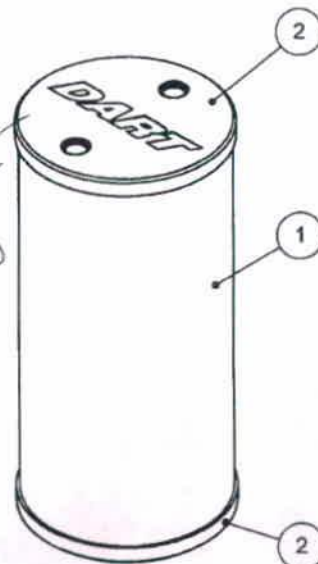
| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3262 | REV. C SHEET 1 OF 2 |
| DATE 06.08.31 | | TITLE FUEL PURGE CANISTER | SCALE 1:4 |
| REV | DATE | DESCRIPTION | |
| A | 04.05.06 | FIRST ISSUE | |
| B | 05.02.14 | ADD PRESSURE TESTING OPTION | |
| C | 06.08.31 | Ø5.165 WAS Ø5.190 | |

RELEASED06.09.19 *[Signature]***UNDER REVIEW***09/01/12*
*CR 09-004***D3262-041 CANISTER ASSEMBLY**

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|-------------------|
| | X | D3362-041 | CANISTER ASSEMBLY |
| 1 | 1 | D3262-1 | TUBE |
| 2 | 2 | D3262-3 | CAP |

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

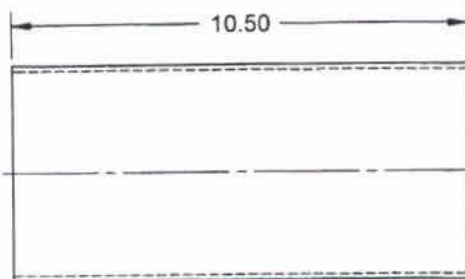
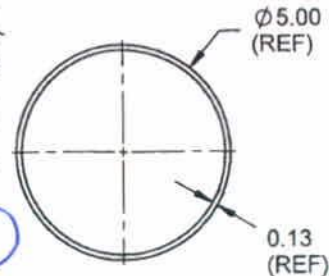


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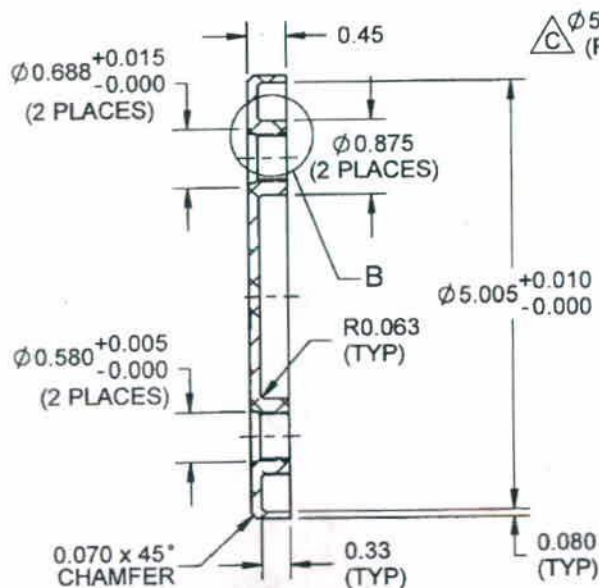
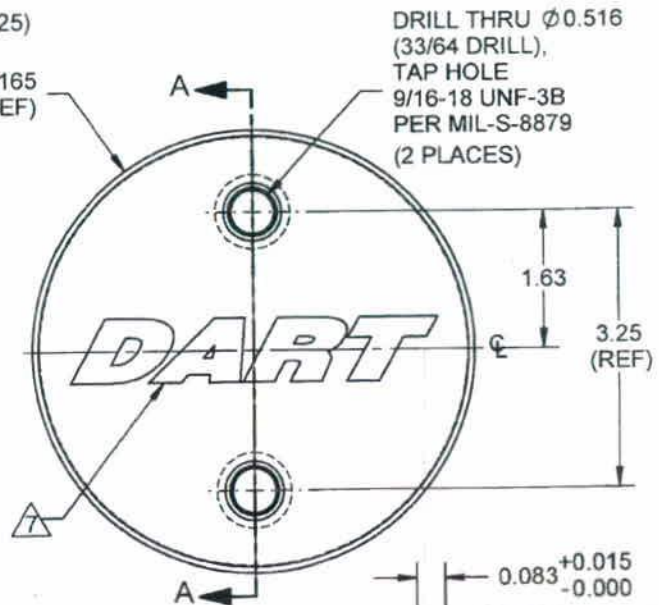
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DART

| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED PH | APPROVED <i>[Signature]</i> | DRAWING NO. D3262 | REV. C SHEET 2 OF 2 |
| DATE 06.08.31 | TITLE FUEL PURGE CANISTER | | SCALE 1:4 |

UNDER REVIEW
[Signature]
CAR 09-004RELEASED
[Signature]
06.09.19**D3262-1 TUBE**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)

**SECTION A-A**
SCALE 1:2

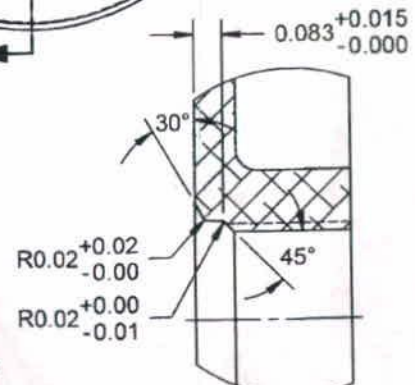
DRILL THRU $\phi 0.516$
(33/64 DRILL),
TAP HOLE
9/16-18 UNF-3B
PER MIL-S-8879
(2 PLACES)

D3262-3 CAP

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

**DETAIL B**
SCALE 2:1

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L Lacelle

From: Mike Petsche [mpetsche@dartaero.com]
Sent: January 6, 2010 8:13 AM
To: 'L Lacelle'
Cc: 'Roberto Fuentes'; 'David Shepherd'
Subject: RE: canisters

Knock yourself out

(Yes....the B205 ones are ok. Just the 212/412 are the issue. Eng will sign off)

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 06, 2010 7:29 AM
To: mpetsche@dartaero.com
Cc: 'Roberto Fuentes'; 'David Shepherd'
Subject: canisters
Importance: High

We have another 205 fuel purge canister to ship next Friday, but the canisters are still under review...can we make any of these to help this customer out? Need an answer asap please

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd